

Work Order ID 60011

Tuesday, June 22, 2010 3:22:11 PM



Page 1

Item ID:	D4044-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Center Rib Assembly				Stop	
Start Date:	6/22/2010	Start Qty:	2.00			
Required Date:	7/30/2010	Req'd Qty:	2.00			
Reference:				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:		Date:	10/06/23	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4044	A								

100		0.00							
Large Fab									
Large Fab									
	Memo	0.00							
	1- Cut tube 60" and remove identification markings								
	2- Bend tube with manuel pipe bender as per template DT9579 (Make first line at 15.00")				SAD 10-06-23				
	3- Drill and chamfer holes in D4044-3 as per dwg D4044								
	4- Trim access tube material to finish size as per dwg D4044								
	5- weld bushing as per dwg D4044								
	A/R S.S. rod Batch: H108775								
	6- grind welds flush								

110		0.00							
QC									
Quality Control									
	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
					S10/06/23				

P12 →

② RD 10.06.23

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4044-013 PAR #: _____ Fault Category: Change Pkt. NCR: Yes No DQA: ✓ Date: 10-06-23
 Resolution: _____ Disposition: _____ QA: N/C Closed: ✓ Date: 10/06/24

NCR: <u>60011</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10-06-23</u>	<u>106</u>	<u>Scrap First Part because line on jig wasn't Exact, & line was off by 1/8 on Second bend</u> <u>R.C. Tooling.</u>	<u>[Signature]</u>	<u>Scrap & destroy</u> <u>- replace qty 1</u> <u>- remove scribble line on jig & re-identify the bend tangent line.</u>	<u>SAD</u> <u>10-06-23</u>	<u>[Signature]</u> <u>10/06/23</u>	<u>[Signature]</u> <u>10/06/23</u>	<u>[Signature]</u> <u>10/06/23</u>

NOTE: Date & initial all entries

Work Order ID 60011

Tuesday, June 22, 2010 3:22:11 PM



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Item ID: D4044-043

Accept



Setup Start



Revision ID:

Item Name: Center Rib Assembly

Stop



Start Date: 6/22/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/06/23

②

130



Packaging

Packaging

Identify as per dwg & Stock Location: Basket

0.00

Memo

0.00

②

10/06/23

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/24

R/ 10-6-24
②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 22, 2010 3:22:16 PM

Page 1

Work Order ID: 60011

Parent Item: D4044-043

Parent Item Name: Center Rib Assembly

Start Date: 6/22/2010


Required Date: 7/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per dwg
revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1		Manufactured	No			100	Each	96.0000	3	6			
													
Bushing													

Location Loc Qty Loc Code

WA 96

54072 9

59419 45

59644 42

M304TS0.750W.049		Purchased	No			100	f	446.7945	5	10.52632			
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304 SQ Tube .75x.75x.049W

Location Loc Qty Loc Code

MAT 146.7944919

113763 0

114323 28.3020789

114677 14.34201

114835 104.150403

MAT017 3.68448E-05

114298 3.6845E-05

WA 300

114992 300

PD 10.06.23

(10)

SAD 10-06-23

10.52632

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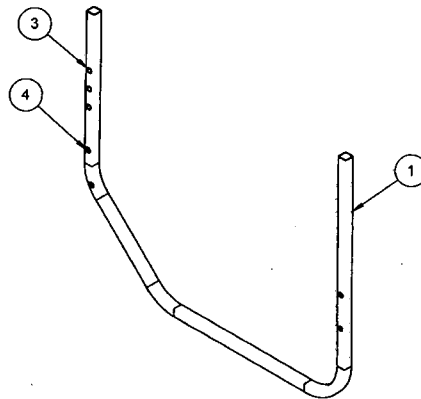
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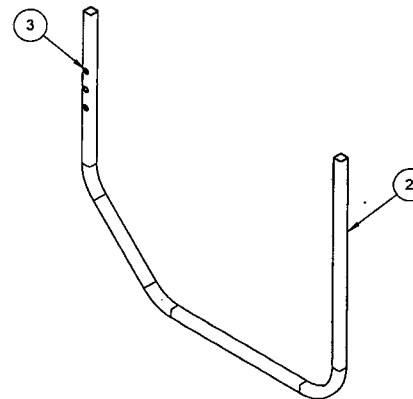
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 WITHOUT NOTICE
 WORK ORDER
 NO. 60284
B/10-6-22

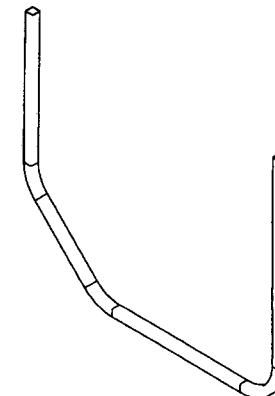
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4044-041	FWD RIB ASSY
		X	D4044-043	CENTER RIB ASSY
1	1		D4044-1	FWD RIB
2		1	D4044-3	CENTER RIB
3	3	3	D3759-1	BUSHING
4	4		D4021-9	BUSHING



D4044-041 FWD RIB ASSEMBLY



D4044-043 CENTER RIB ASSEMBLY



D4044-5 AFT RIB

RELEASED
 2010-02-16
W

A		NEW ISSUE		RF	10.01.29
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	RF			SHEET 1 OF 5	
CHECKED	<i>RF</i>	DRAWING NO.		SCALE	
MFG. APPR.	<i>RF</i>	D4044		NTS	
APPROVED	<i>RF</i>	TITLE			
DE APPR.	<i>RF</i>	RIB ASSEMBLY			
DATE		10.01.29		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Dart Aerospace Ltd

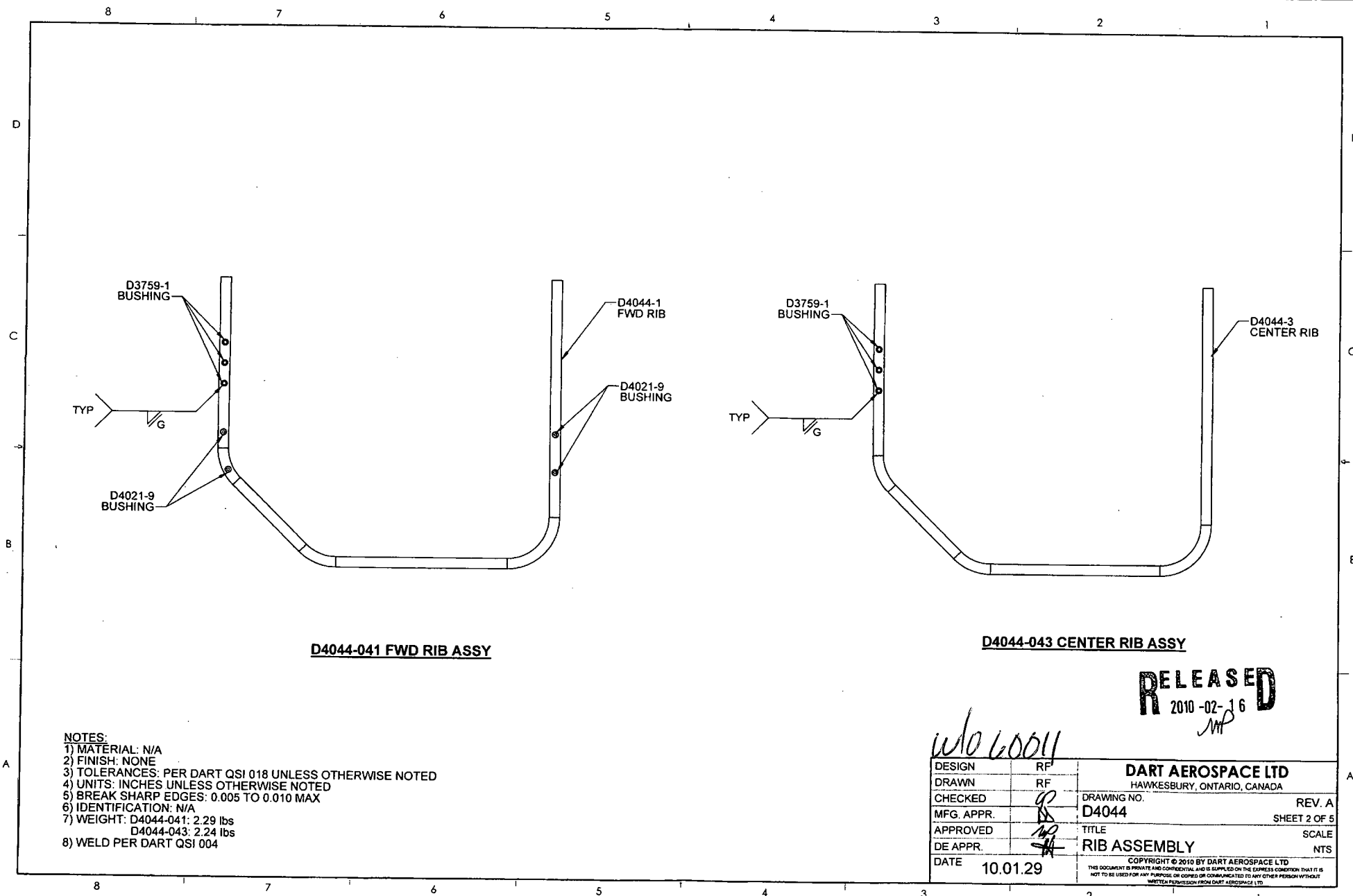
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4044-041 FWD RIB ASSY

D4044-043 CENTER RIB ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4044-041: 2.29 lbs
D4044-043: 2.24 lbs
- 8) WELD PER DART QSI 004

RELEASED
2010-02-16
MP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4044	SHEET 2 OF 5
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DE APPR.	MP	RIB ASSEMBLY	NTS
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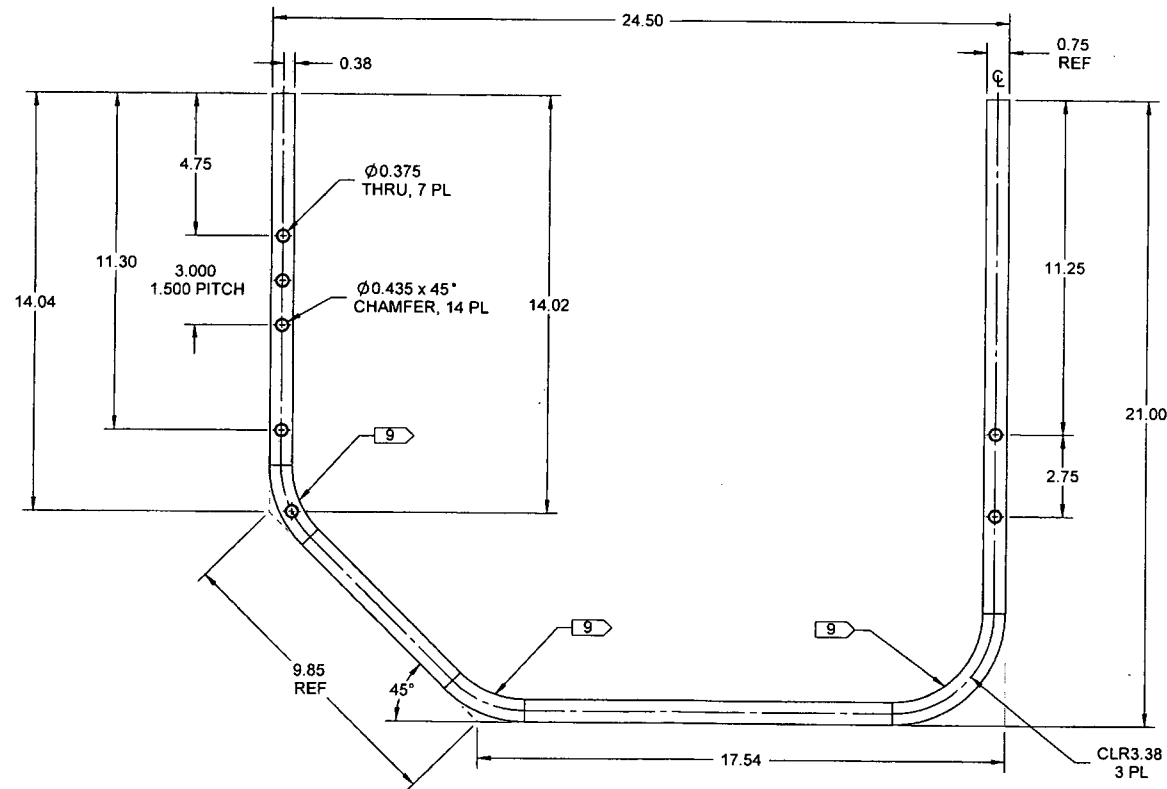
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D4044-1 FWD RIB

RELEASED
2010-02-16
WP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.750 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.19 lbs
- 8) TUBE FLAT LENGTH 59.31 REF
- 9) ALLOWABLE WRINKLING IN BENDS UP TO 0.15" DEEP MAX

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WP	DRAWING NO.	REV. A
MFG. APPR.	WP	D4044	SHEET 3 OF 5
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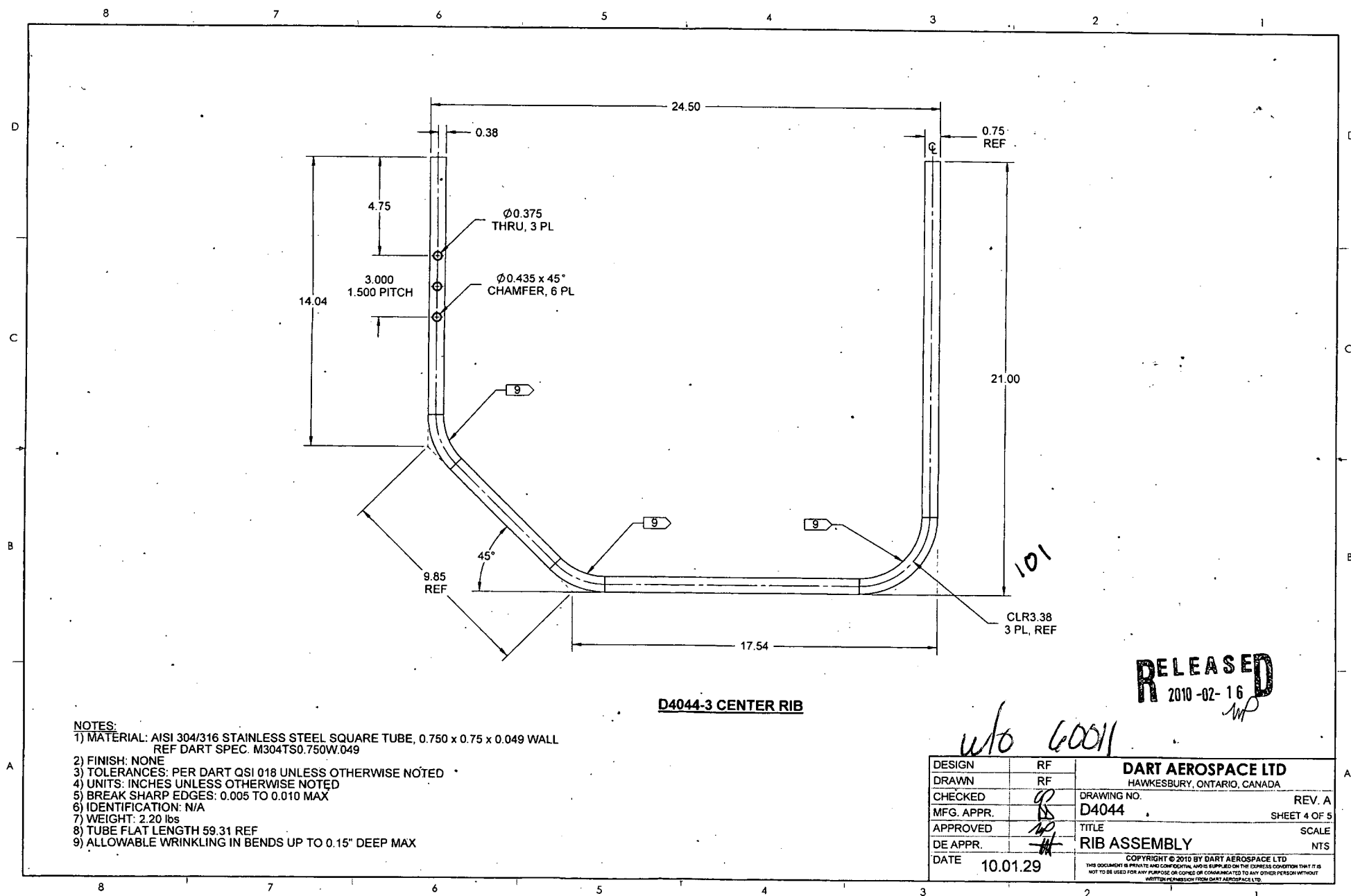
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